

Work Order ID 150817

Thursday, September 08, 2016 8:04:19 AM

150817

Page 1

Item ID: D412-630-033DG

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/30/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-630

Rev O

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & create labels per PPP D412-630-033 CHG005

DAS
27
9-89

SEP 22 2016

DAS
21
9-89

16-09-08

110

Small Fab

0.00

110

Small Fab

Memo

0.21

Small Fab

Assemble as per dwg D412-630 p.14
Coat all hardware with LPS3 rust inhibitor
A/R LPS3 batch: 123777
COAT exposed HARDWARE WITH LPS PROCYON.
A/R LPS PROCYON BATCH: 133690

4X

16/09/21 DAS
36
9-89

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150817

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 9/30/2016 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

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Item ID: D412-630-033DG Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green
Start Date: 9/8/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 9/30/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00							
150	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-033								
Packaging	Location: _____ PPP Rev: _____ <i>sld</i>								
160	QC21- Final Inspection - Work Order Release	0.00							
160	Memo	0.07							
QC									
Quality Control									

44
DAS
27 28
9-89 9-89
SEP 22 2016

DAS
21
9-89
SEP 22 2016
dm 10/09/22

Picklist Print

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Work Order ID: 150817

150817

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn 1019, added d2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC IPP REV:D
13.06.07 PER CHG004 DD vef:JLM IPP REV:E 16.06.23
AS PER IIN REV.O DD VEF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8 Nut		Purchased	No			110	Each	24.0000	2	8			
**													DAS 6 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST331		24							
				m132677		4							
				m135297		20							
AN3C21A Bolt		Purchased	No			110	Each	21.0000	1	4			
**													DAS 6 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST348		21							
				M133686		21							
AN8C16 Bolt		Purchased	No			110	Each	39.0000	2	8			
**													DAS 6 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				over005		21							
				M133920		7							
				M133921		7							
				M134131		7							
				ST332		18							
				M132674		4							
				M133091		7							
				M133336		7							

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Work Order ID: 150817

150817

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

D2012-107 Manufactured No

110 Each 59.0000 1✓ 4

D2012-107

Clevis

**

DAS
6
9-89

Location

Loc Qty

Loc Code

WA004

59

145274

8

149315

51

SEP 12 2016

D2803-041 Manufactured No

110 Each 8.0000 1✓ 4

D2803-041

Bracket Assembly

**

DAS
36
9-89

Location

Loc Qty

Loc Code

ST472

8

148426

8

16/09/21
B149455 (42)

D2804-041 Manufactured No

110 Each 1.0000 1 4

D2804-041

Bracket Assembly

**

DAS
36
9-89

Location

Loc Qty

Loc Code

ST474

1

148422

1

16/09/21
B149404 (42)

D2807-041 Manufactured No

110 Each 37.0000 2 8

D2807-041

Prop Assembly

**

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

2

89606

2

ST011

35

142559

1

148998

4

149206

30

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Work Order ID: 150817

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Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

D2813 Manufactured No 110 Each 122.0000 2 8

D2813

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

ST011

122

146527

18

149366

104

8

D3395-1

Manufactured No

110 Each 264.0000 4 16

D3395-1

Bushing

DAS
6
9-89

Location

Loc Qty

Loc Code

ST034

264

142347

62

149467

202

16

D3562-041

Manufactured No

110 Each 0.0000 1 4

D3562-041

Step Weldment

B147389

(4x)

SEP 12 2016

DAS
36
9-89

16/09/21

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Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

110

Each

1,202.000

4

16

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

11

m130673

11

GA

235

m133990

235

ST302

807

m135058

7

m135442

400

m135544

400

ST304

69

m131340

69

MS24665-302

Purchased

No

110

Each

29.0000

2

8

MS24665-302

Cotter Pin

Location

Loc Qty

Loc Code

GA

15

120521

15

ST288

14

m134738

14

MS24693-C280

Purchased

No

110

Each

11.0000

2

8

MS24693-C280

SCREW

Location

Loc Qty

Loc Code

ST287

11

m131624

11

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89

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Shop Packet Print

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Work Order ID: 150817

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Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

MS24693-C285

Purchased

No

110

Each

28.0000

1

4

MS24693-C285

Screw

DAS
6
9-89

Location

Loc Qty

Loc Code

ST287

28

m134558

28

AN44C7A

Purchased

No

130

Each

11.0000

1

4

AN44C7A

Eyebolt

DAS
6
9-89
28
9-89

Location

Loc Qty

Loc Code

ST339

11

m134502

2

m135127

9

AN4C10A

Purchased

No

130

Each

17.0000

1

4

AN4C10A

BOLT

28
9-89

Location

Loc Qty

Loc Code

ST345

17

M134497

7

M135390

10

DAS
27
9-89

DAS
6
9-89

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Work Order ID: 150817

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Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

AN4C15A

Purchased

No

130

Each

96.0000

2

8

AN4C15A

Bolt

DAS
6
9-89
28
9-89

Location

Loc Qty

Loc Code

FG

10

120360

10

OVER002

50

M132763

20

M133485

30

ST343

36

M130716

22

M132189

8

M132823

6

8

DAS
27
9-89

AN4C6A

Purchased

No

130

Each

590.0000

1

4

AN4C6A

Bolt

DAS
6
9-89
28
9-89

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

OVER002

450

m135297

50

m135470

400

over003

126

m135442

126

4

DAS
27
9-89

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Work Order ID: 150817

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Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

AN5C15A

Purchased

No

130

Each

121.0000

2

8

AN5C15A

Bolt

DAS 28
6 9-89
9-89

Location

Loc Qty

Loc Code

over003

110

M135442

110

ST337

11

M135058

11

130

Each

119.0000

2

8

DAS 28
6 9-89
9-89

D2806-1

Manufactured

No

D2806-1

Bushing

Location

Loc Qty

Loc Code

ST011

18

142466

2

148274

16

ST012a

101

149371

101

130

Each

117.0000

2

8

DAS 28
6 9-89
9-89

D2806-3

Manufactured

No

D2806-3

Bushing

Location

Loc Qty

Loc Code

ST011

16

148330

16

ST012a

101

149456

101

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Work Order ID: 150817

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Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

D2810-5

Manufactured No

130

Each

6.0000

1

4

D2810-5

Strut

**

B149357 DAS 28
6 9-89

Location

Loc Qty

Loc Code

ST377

6

134899

1

142838

5

D3396-1

Manufactured No

130

Each

108.0000

2

8

D3396-1

Spacer

**

DAS 28
6 9-89

Location

Loc Qty

Loc Code

ST034

6

142351

6

ST038A

102

149446

102

D3672-17

Manufactured No

130

Each

354.0000

7

28

D3672-17

Phenolic Washer

**

DAS 28
6 9-89

Location

Loc Qty

Loc Code

ST050

354

148074

354

D3672-19

Manufactured No

130

Each

416.0000

4

16

D3672-19

Phenolic Washer

**

DAS 28
6 9-89

Location

Loc Qty

Loc Code

ST050

416

148075

416

SEP 12 2016

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Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

D3672-5

Manufactured No

D3672-5

Washer, Phenolic

012
130 Each

622.0000 7 28

DAS
6
9-89

28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	8	
44679	8	
ST049	234	
35521	234	
ST051A	380	
50354	380	

110
130

883.0000 4 16

DAS
6
9-89

D3672-7

Manufactured No

D3672-7

Washer, Phenolic

Location

Loc Qty

Loc Code

FG	40	
129987	25	
133986	15	
ST049	343	
147220	343	
ST057A	500	
149431	500	

14

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Work Order ID: 150817

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Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

130

Each

735.0000

4

16

MS21043-4

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

17

m132803

17

OVER007

300

m135530

300

ST302

378

m135390

78

m135407

300

DAS
27
9-89

16

MS21043-5

Purchased

No

130

Each

136.0000

3

12

MS21043-5

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

72

116548

72

ST302

44

m135157

2

m135470

42

DAS
27
9-89

12

SEP 12 2016

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Work Order ID: 150817

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Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

D3672-15

Manufactured No

M *110*
120

Each

731.0000

5

20

D3672-15

Phenolic Washer

Location

Loc Qty

Loc Code

ST050

231

148073

231

ST051A

500

149430

500

20

D4S
6
886

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
7	7			D3672-5	WASHER (OR NAS1515H5)
		4	4	D3672-7	WASHER (OR NAS1515H5L)
		5	5	D3672-15	WASHER (OR NAS1515H3)
7	7			D3672-17	WASHER (OR NAS1515H4)
		4	4	D3672-19	WASHER (OR NAS1515H8)
		1	1	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C65)
		1	1	MS24693-C285	SCREW (OR MS24694-C76)

Work Order ID 150817

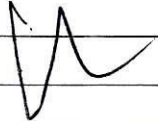
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Auto - Sept

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Thursday, September 08, 2016 8:04:19 AM

Item ID: D412-630-033DG Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green
 Start Date: 9/8/2016 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 9/30/2016 Req'd Qty: 4.00 *4* Customer:

Reference:
 Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-630	Rev O								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & create labels per PPP D412-630-033 CHG005								
110	Small Fab	0.00							
110									
Small Fab	Memo	0.21							
Small Fab	Assemble as per dwg D412-630 p.14								
	Coat all hardware with LPS3 rust inhibitor								
	A/R LPS3 batch: _____								
	COAT exposed HARDWARE WITH LPS PROCYON .								
	A/R LPS PROCYON BATCH: _____								

DAS 21 9-89 SEP 08 2016


Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
7	7			D3672-5	WASHER (OR NAS1515H5)
		4	4	D3672-7	WASHER (OR NAS1515H5L)
		5	5	D3672-15	WASHER (OR NAS1515H3)
7	7			D3672-17	WASHER (OR NAS1515H4)
		4	4	D3672-19	WASHER (OR NAS1515H8)
		1	1	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C65)
		1	1	MS24693-C285	SCREW (OR MS24694-C76)